Work Orde Wednesday, Octo											
Revision ID:	D3574-6		4	Accept				s	etup Sta	1 (88)	
	Cabin Floor Pro 10/6/2010 10/15/2010	Start Qty: 3.00 Req'd Qty: 3.00			Cust Item Customer:	ID:			50	ор 	
	Process Plan	n:	Date: <u>//১/০/0/</u> Date:	Tooling: SPC (Y/N):		ate:		R			
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. er Stamp
Draw Nbr D3574	Revi	sion Nbr B									
Waterjet FLOW CNC Waterje	t	FLOW WATER JET Memo 1-Cut as p Deburr if r	er Dwg D3574 □Dwg Rev necessary	0.00 0.00 : S □Prog Rev:	<u>B</u>			IB (0	D <u>-10</u> -	·6	
110 QC QC Quality Control		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				<u> </u>)-10-(#: 0	

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

000 > 10/10/06

و بعر ای اید

Dait Ac	ospace	Ltu							
W/O:			WC	RK ORDER CHANG	ES				*
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	າ:	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	₹)			
_		Description of NC		Corrective Action Section	on B	Vorifi	nation	Ammunual	Ammassal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date			Approval Chief Eng	Approval QC Inspector
					_				
141									

Work Order ID 62694

Wednesday, October 06, 2010 11:14:01 AM



Page 2

Item ID:

D3574-6

Accept

Setup Start

Stop



Revision ID:

Item Name:

Cabin Floor Protector

Start Date:

10/6/2010

Start Qty: 3.00 **Required Date:** 10/15/2010

Req'd Qty: 3.00



Cust Item ID: Customer:

Tool ID

Reference:

А	pp	rov	/al	s:

Date:____ Date:

Tooling: SPC (Y/N):

Date:

Tool # Plan

Date:

Run Start

Insp.

Reject

Stop

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation **Description**

Small Fab

Memo

Deburr if necessary.

Set Up/ **Run Hours**

0.00

0.00

Qty Qty Code Number Stamp

Reject

Accept

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location:

Memo

150

Packaging

Memo

0.00

0.00

Packaging

Dart Ae	rospace l	Ltd						
W/O:			WO	RK ORDER CHANGI	ES			*
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _	
	Res	solution:	Disposition	:	QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)		
DATE	0750	Description of NC	Corrective Action		on B	Verificati	ion Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section (QC Inspector
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	· · · · · ·	J. F. Marie				- 		

Work Order ID 62694

Wednesday, October 06, 2010 11:14:01 AM



Page 3

Item ID:

D3574-6

Accept



Setup Start



Revision ID:

Item Name:

Cabin Floor Protector

Start Date:

10/6/2010

Start Qty: 3.00

Req'd Qty: 3.00

Operation

Description



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:_ Date:

SPC (Y/N):

Tooling:

Set Up/

Run Hours

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

Required Date: 10/15/2010

Memo

QC21- Final Inspection - Work Order Release

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

160

0.00

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W/O:			WC	RK ORDER CHANG	ES				1	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Category: NC			_ NCR: Yes No DQA: Date:				
	Re	esolution:	Disposition	1:	_ QA: N/C	Closed: _		Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NO	CR)				
DATE	STEP	Description of NC	Corrective Action Section			Veri	fication	Approval	Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n& _{Se}	ection C	Chief Eng	QC Inspector	
				e en						
•										
*										

Picklist Print

Wednesday, October 06, 2010 11:14:05 AM

Work Order ID: 62694

Parent Item: D3574-6

Parent Item Name: Cabin Floor Protector



Start Date: 10/6/2010

Required Date: 10/15/2010

Page 1

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev : A New Issue 07.07.23

EC

verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No		,		sf	2,185.803	33.6	100.8504	130) ,	
CE DI ACTICC LEYAN CH											B10-10		

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
MAT	2185.8038	
114032	184.9238	
115261	2000.88	



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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A :	Date: _	
Resolution:			Disposition):	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
		Description of NC	Corrective Action		on B	Vorifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	62694
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension	ļ			
Ø3.00	+0.006/-0.001	3,004	X		U BOD	
7.37	+/-0.030	7,37	*		7 BO1	·
11.00	+/-0.030	11,00	A		7	
15.25	+/-0.030	15.25	0		7	
25.87	+/-0.030	78.76	×		1	-
39.75	+/-0.030	39.75	&		7	
44.75	+/-0.030	44,75	*		T	
58.38	+/-0.030	58.38	Ý.		T	-
63.50	+/-0.030	63.50	×		7	
65.25	+/-0.030	65.28	b		T	
40.05	. / 0 000		<u> </u>		-	
10.25	+/-0.030	16.75	%		T	
11.87	+/-0.030	11.87	*		T	
14.75	+/-0.030	14.74	*		T	
26.00	+/-0.030	96.66	*	<u> </u>	T	
40.87	+/-0.030	40.67	A		T	
45.00	+/-0.030	45.00	*		T	
48.00	+/-0.030	48.60	*		7	÷-
55.13	+/-0.030	55.13	*		T	·
61.25	+/-0.030	61.74	*		7	
61.88	+/-0.030	61.88	*		7	
64.63	+/-0.030	64.63	₩		7	
1.13	+/-0.030	1.13	*		٦	
7.63	+/-0.030	7.63	&		Т	
11.00	+/-0.030	11.00	8≱		Т	
22.10	+/-0.030	33.10	8		7	
22.50	+/-0.030	22.50	₹		7	
24.50	+/-0.030	74.50	84		٢	
35.13	+/-0.030	35.13	*		7	
36.50	+/-0.030	36.56	8		τ	. ,
40.00	+/-0.030	40.06	&		7	
41.88	+/-0.030	41.88	•		τ	
43.63	+/-0.030	4363	7		т	
			,			
6.75	+/-0.030	6.75	Ä		7	
9.50	+/-0.030	9.50	9		_ \	·

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAI	IGE	В	y .	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								<u> </u>				
Part No	:	PAR #:	PAR #: Fault Category:									
	R	esolution:	QA: N/	C Clos	sed:		Date:					
NCR:		,	WORK ORDE	R NON-CONFORM	IANCE (N	ICR)						
DATE	STEP	Description of NC			tion B Verific				Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Section C		Chief Eng	QC Inspector		
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DART AEROSPACE LTD	Work Order:	42494
Description: Cabin Floor Protector	Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

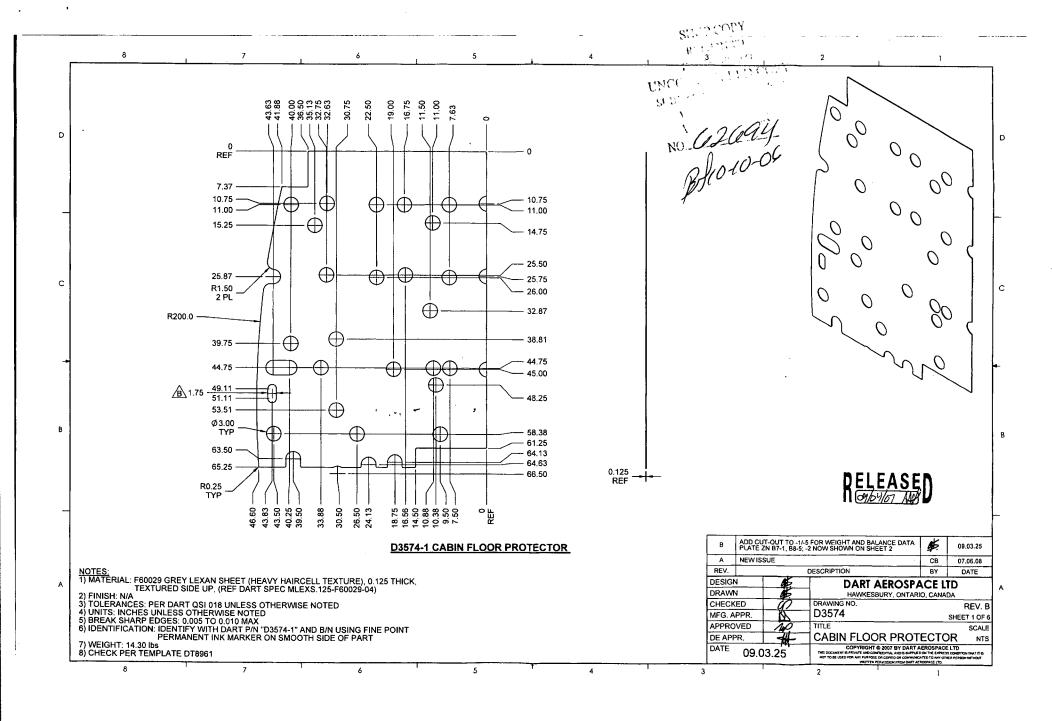
х	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	X		T 1301	
14.50	+/-0.030	14,56	Ø		Т	
16.75	+/-0.030	16.75	<i>X</i> 5		7	
18.94	+/-0.030	18.94	D		T	
19.00	+/-0.030	14.00	D		7	
24.13	+/-0.030	24.B	7		τ	
33.88	+/-0.030	33.88	7		T	
39.50	+/-0.030	39,50	Υ		1	
40.25	+/-0.030	40.25	٦		7	
43.50	+/-0.030	43.50	2		<u> T </u>	
46.60	+/-0.030	46.60	2		T	
0.125	+/-0.010	1.98	8		V 1803	

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10-10-6	Date: IP 10 0C	Date:	N/A
			. 1

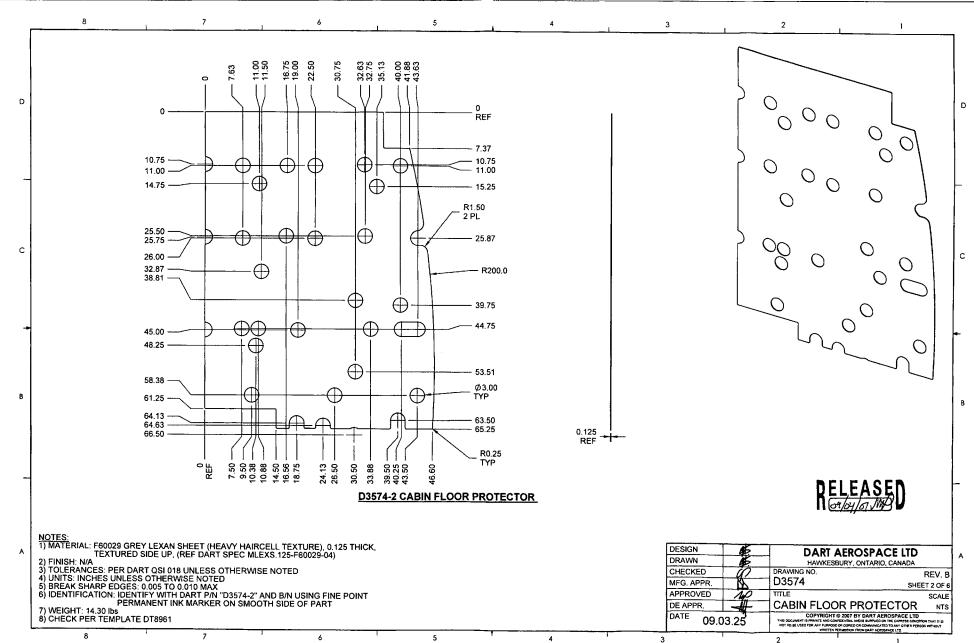
Rev	Date	Change	Revised by	Approved=
Α	08.01.16	New Issue	KJ//DD	
В	09.05.15	Dimensions updated per Dwg Rev B	KJ 95	

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
						7-7-1						
Part No	:	PAR #:	Fault Cate	NCR: Yes	No DQ	A: Date:						
	Re	solution:	Disposition	n:	QA: N/C CI	osed:		Date: _				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			-			
DATE	STEP	Description of NC	ļ <u>.</u>	Corrective Action Section		Verific	cation	Approval	Approval			
——————————————————————————————————————	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector			
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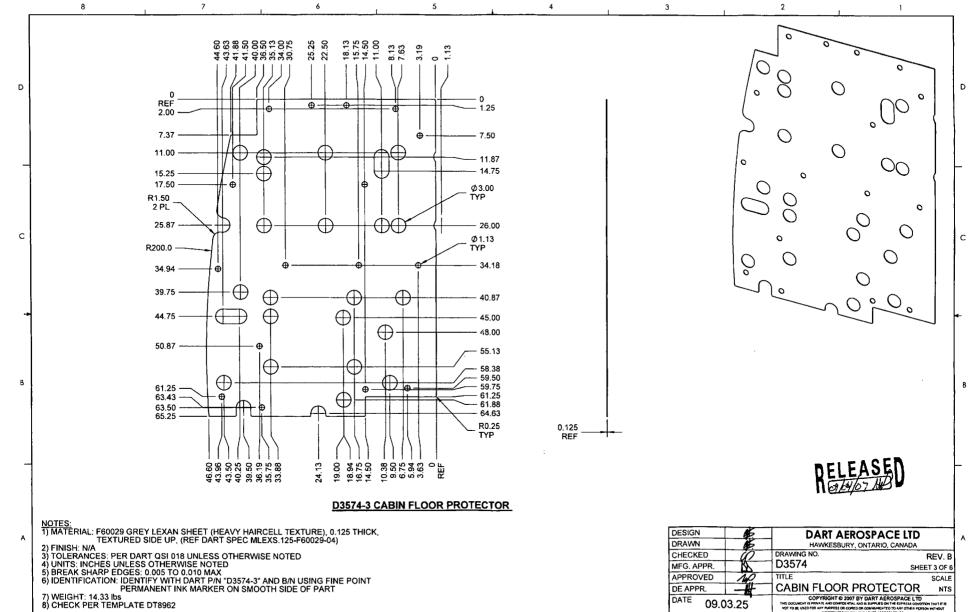
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DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:			_ Fault Ca	Fault Category: NCR: Yes No DQA:				Date:	
Resolution: Disp									
NCR:		W	ORK OR	DER NON-CONFORMAI	NCE (NCF	R)	•		
DATE	STEP	Description of NC	Corrective Action Section			Verification verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	<u>С</u>	Chief Eng	QC Inspector
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W/O:			WO	RK ORDER CHANG	ES				ì
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category: NO			No DQ	A:		
	Res	olution:	Disposition	:	_ QA: N/C C	losed:		Date: _	·-····································
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STED	Description of NC	Description of NC Corrective Action		······································			Approval	Approval
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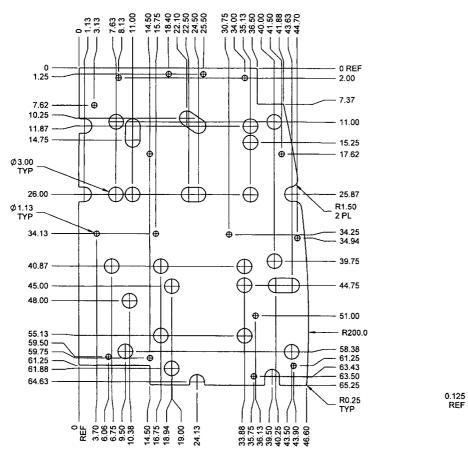
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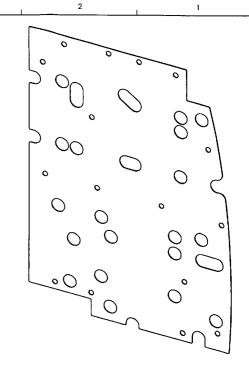


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	Re	esolution:	Dispositio	n:	QA: N	C Clos	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE (I	VCR)				
DATE	STEP	Description of NC			ction B	V		cation	Approval	Approval
DAIL	SILF	Section A			tion Sign & Date		& Section C		Chief Eng	QC Inspector
							,			

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D3574-4 CABIN FLOOR PROTECTOR

NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

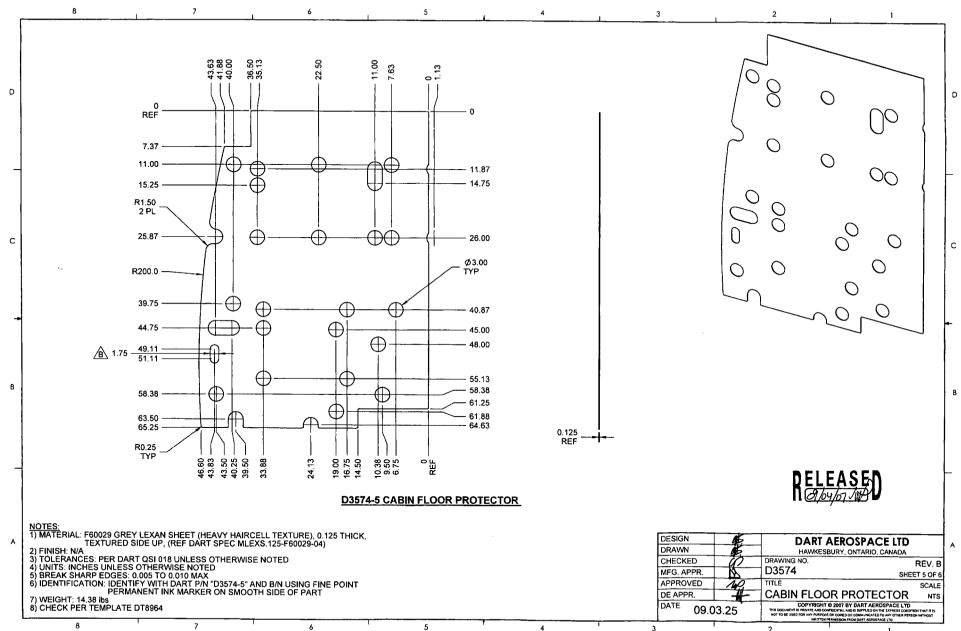
- 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs 8) CHECK PER TEMPLATE DT8963

DESIGN	1	DART AEROSPACE LTD						
DRAWN	16	HAWKESBURY, ONTARIO, CANADA						
CHECKED	0	DRAWING NO.	REV. B					
MFG. APPR.	100	D3574 sher	ET 4 OF 6					
APPROVED	10	TITLE	SCALE					
DE APPR.	4	CABIN FLOOR PROTECTOR	NTS					
DATE 09.0	3.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED OF THE EXPRESS CONSTITION THAT IT IS NOT THE REPORT OF CONFIDENCE AND CONFIDENCE AND THE EXPRESS CONSTITION THAT IT IS						

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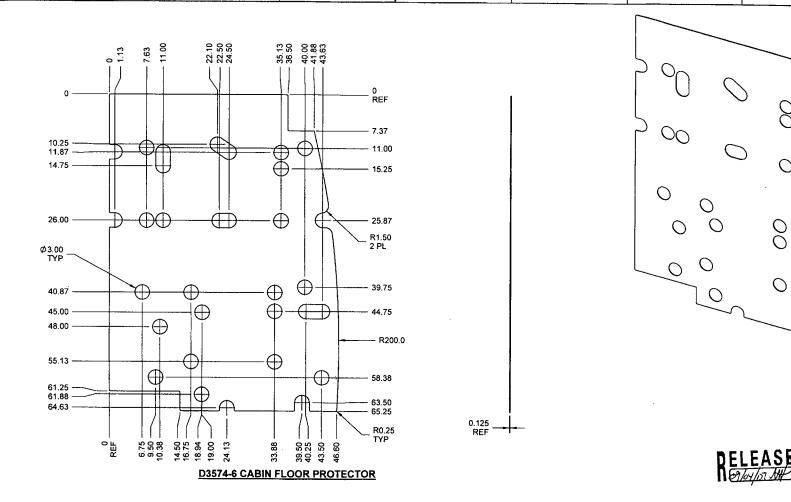
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DATE	STEP	PR	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: D				
	Res	olution:	Disposition	າ:	_ QA: N/C CI	osed:		Date: _	
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DATE	STED	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval
DAIL	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C		Chief Eng	QC Inspector	
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W/O:			WC	RK ORDER CHANG	ES				3
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	Resolution:		Dispositio	າ:	_ QA: N/C C	losed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip Chief Eng Chief Eng		Section B otion Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
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NOTES:
1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK,
TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)

2) FINISH: N/A

2) FINISH: N/A

3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-6" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART

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7) WEIGHT: 14.27 lbs 8) CHECK PER TEMPLATE DT8965

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3574 MFG. APPR. SHEET 6 OF 6 APPROVED CABIN FLOOR PROTECTOR DE APPR. COPYRIGHT © 2007 BY DART AFROSPACE LTD
THE DOCUMENT OF PRIVATE, AND CONTROL AND IS SUPPLIED ON THE EUPRESS CONSTITUINT IN IT TO SE USED FOR ANY PARPOSE OF COMPLEX PLET TO ANY OTHER PRESSOR WITHOUT
WATER PERSON FOR DARY ARROSPACE LTD.

WATER PERSON FOR DARY ARROSPACE LTD. DATE 09.03.25

W/O:			W	ORK ORDER CHANG	ES				,
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No				NCR: Yes No DQA: Date:					
Resolution:			Dispositi	Disposition: (Closed:		Date:	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1& _{Sect}	& Section C		QC Inspector
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